

84403

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/05/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 17/05/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

[illegible]

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Page 2

Quality Control

6

1205-14

6a

12/5/14

12/5/14

MF
12-05-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

May-11-12 10:34:30 AM

Page 1

Work Order ID: 84403

84403

Parent Item: D4542-3

D4542-3

Parent Item Name: Retainer, Inner

Start Date: 11/05/2012

Required Date: 17/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg revA DD verf:EC IPP REV:C 12.05.08 as
per dwg revB DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6S.032

Purchased

No

100

sf

285.2160

0.252

1.061053

Z

M6061T6S 0.32

**

RIZ-5-11

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

285.216

118106

46.606

120218

28.77

120285

42.24

121099

167.6

121099

6

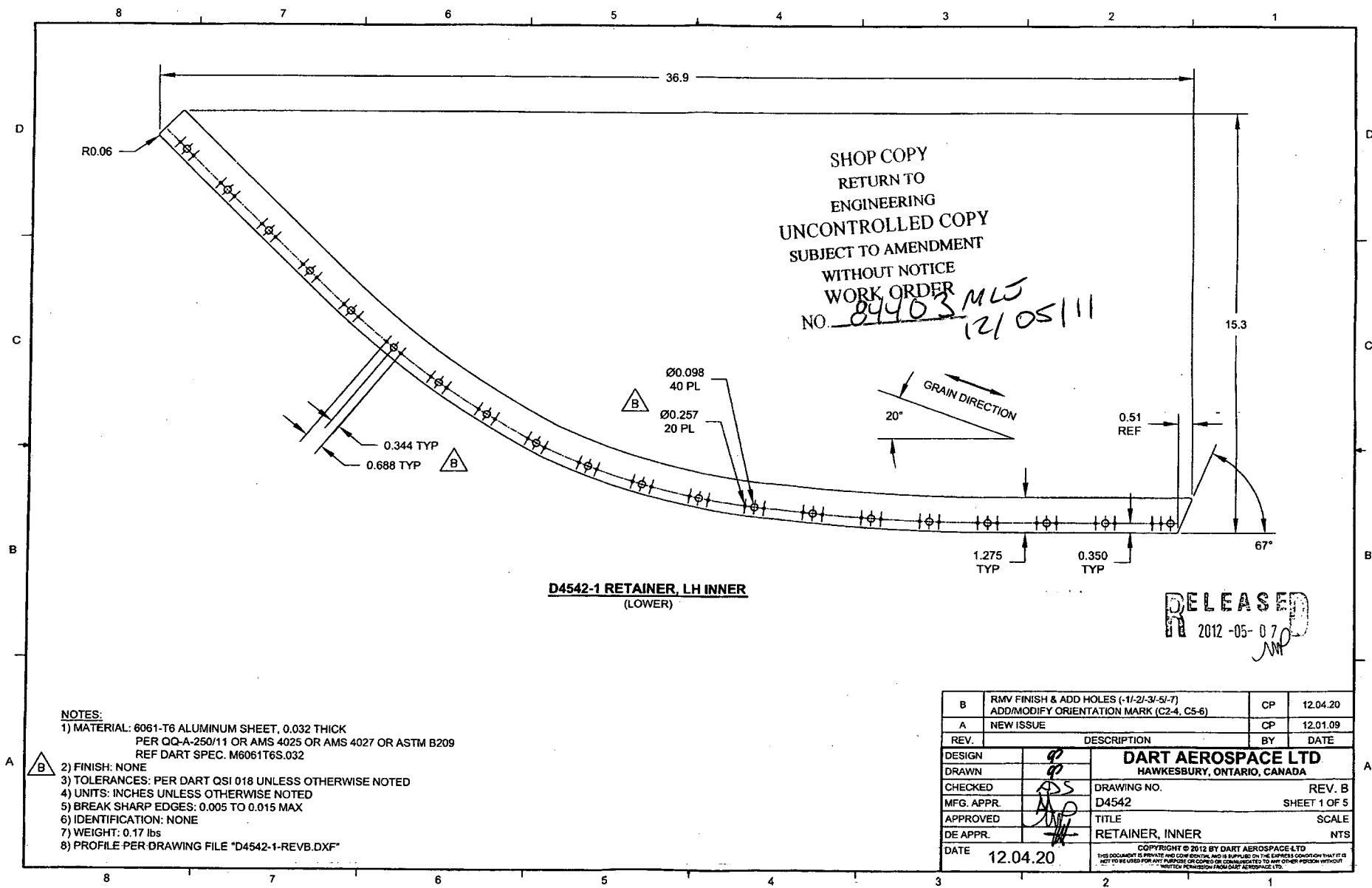
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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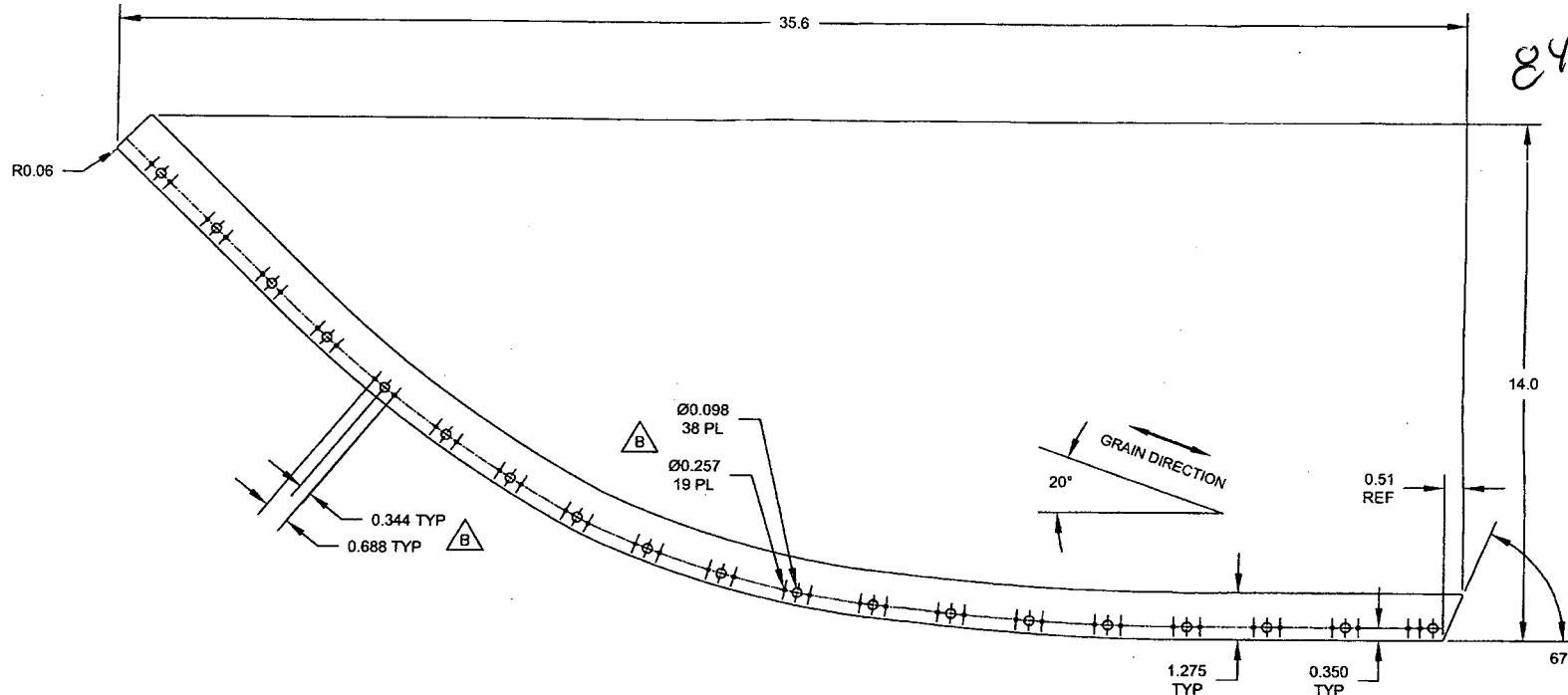
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

84403



D4542-2 RETAINER, RH INNER
(LOWER)

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs
- 8) PROFILE PER DRAWING FILE "D4542-2-REVB.DXF"

| | | | |
|--|----------|---|--------------|
| DESIGN | 92 | DART AEROSPACE LTD | |
| DRAWN | 92 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASS | DRAWING NO. | REV. B |
| MFG. APPR. | AP | D4542 | SHEET 2 OF 5 |
| APPROVED | AP | TITLE | SCALE |
| DE APPR. | TH | RETAINER, INNER | NTS |
| DATE | 12.04.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD. | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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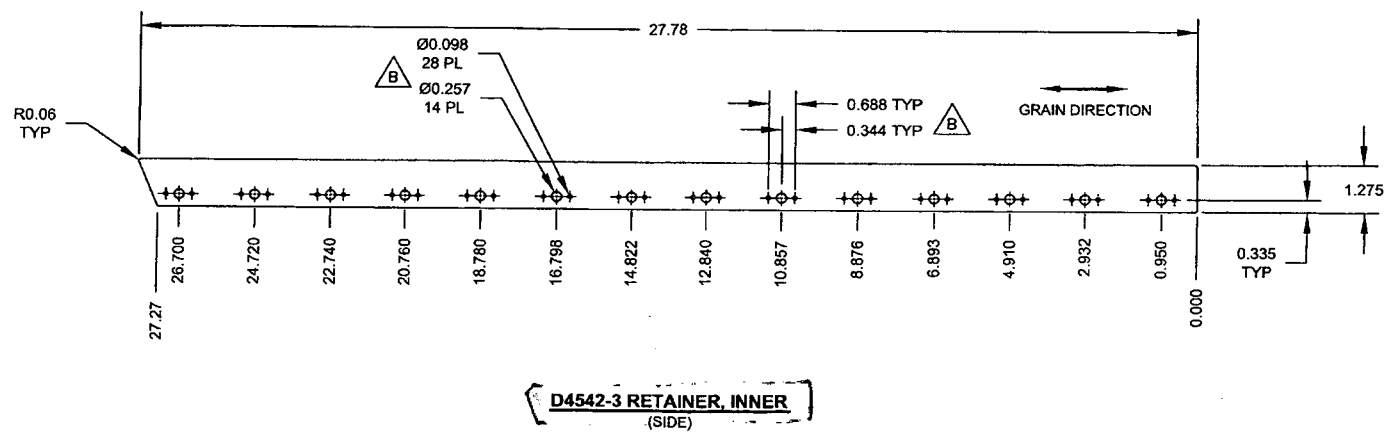
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

844:03



- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.11 lbs
 - 8) PROFILE PER DRAWING FILE "D4542-3-REVB.DXF"

| | | |
|------------|----------|--|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. REV. B |
| MFG. APPR. | | D4542 SHEET 3 OF 5 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | RETAINER, INNER NTS |
| DATE | 12.04.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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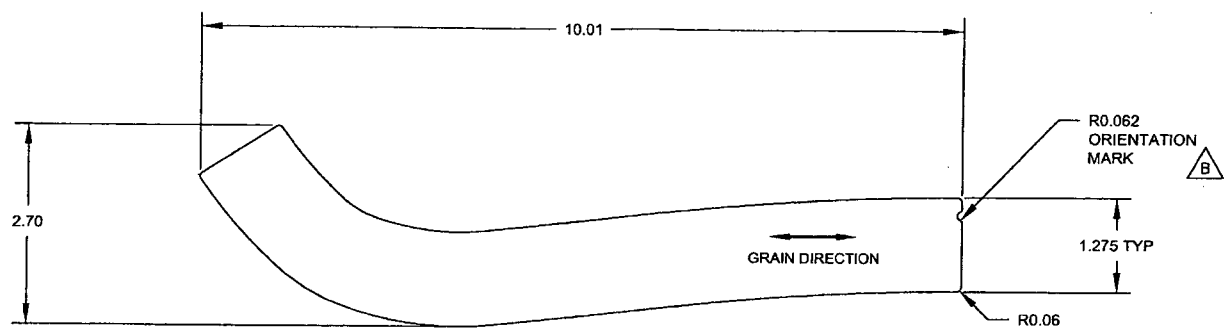
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

84403



D4542-5 RETAINER, INNER
(TOP CORNER)

RELEASE
2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REVB.DXF"

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASS | DRAWING NO. | REV. B |
| MFG. APPR. | | D4542 | SHEET 4 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | RETAINER, INNER | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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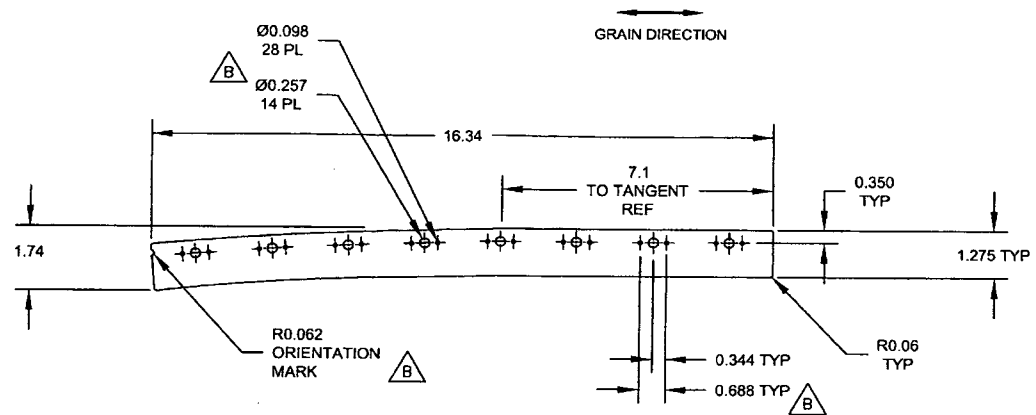
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

E440.3



D4542-7 RETAINER, INNER
(TOP)

RELEASED
2012-05-07

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.07 lbs
 - 8) PROFILE PER DRAWING FILE "D4542-7-REVB.DXF"

| | | | |
|------------|----------|--|--------------|
| DESIGN | DP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | DP | | |
| CHECKED | ASS | DRAWING NO. | REV. B |
| MFG. APPR. | AA | D4542 | SHEET 5 OF 5 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | | RETAINER, INNER | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|---------------------------------------|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 84403 |
| Description: RETAINED INNER | | Part Number: D4542-3 |
| Inspection Dwg: D4542-3 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .098 | + .004 - .001 | .107 | 1 | | ✓ B02 | |
| Ø .257 | + .006 - .004 | .257 | 2 | | ✓ | |
| .335 | ± .010 | .330 | 2 | | ✓ | |
| 1.275 | ± .010 | 1.280 | 2 | | ✓ | |
| .344 | ± .010 | .344 | 2 | | ✓ | |
| .688 | ± .010 | .690 | 2 | | ✓ | |
| .950 | ± .010 | .950 | 2 | | ✓ | |
| 2.932 | ± .010 | 2.933 | 2 | | ✓ | |
| 4.910 | ± .010 | 4.912 | 2 | | ✓ | |
| 6.893 | ± .010 | 6.894 | 2 | | ✓ | |
| 8.876 | ± .010 | 8.876 | 2 | | T B02 | |
| 10.857 | ± .010 | 10.857 | 2 | | T | |
| 12.840 | ± .010 | 12.840 | 2 | | T | |
| 14.822 | ± .010 | 14.822 | 2 | | T | |
| 16.798 | ± .010 | 16.798 | 2 | | T | |
| 18.780 | ± .010 | 18.780 | 2 | | T | |
| 20.760 | ± .010 | 20.760 | 2 | | T | |
| 22.740 | ± .010 | 22.740 | 0 | | T | |
| 24.720 | ± .010 | 24.720 | 2 | | T | |
| 27.78 | ± .030 | 27.78 | 2 | | T | |
| .035 | ± .010 | .033 | 1 | | ✓ | |
| | | | | | | |
| | | | | | | |

| | | | |
|------------------------|--------------------------------|----------------------------|-----|
| Measured by: IB | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 12-5-11 | Date: 12 05 14 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |